

shp 21/12

Date: Monday, 17/12/2007 10:14:52 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT
Job Number	: 36366	Part Number	: D2565201
Estimate Number	: 10955	Drawing Number	: D2565 REV E
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 17/12/2007	Drawing Revision	: E
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 24/12/2007
Previous Run	: 35115	Qty:	4
Written By	:	Um:	Each
Checked & Approved By	:		
Comment	: Est: D 01/06/04 Added Powder Coat, Removed Polish, and Added Inspection Levels 3 & 21 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0750W049	304 RD Tube .750 x .049W	
		Comment: Qty.: 2.0124 f(s)/Unit Total : 8.0497 f(s) Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall (M304TR0750W049)	Batch No: M106132 DB 07/12/18 (4)
2.0	BRAKE NC	NC BRAKE	
		Comment: BRAKE NC Punch as per Dwg D2565 using DT 8313	DB 07/12/18 (4)
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Drill hole as per Dwg D2565 (one end only) Deburr	G 07/12/18 (4)
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	S 07/12/18 (4)
5.0	POWDER COATING	POWDER COATING	
		Comment: POWDER COATING Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3	M 07/12/18 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/01/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STRUT

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Part Number: D2565201

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PL 07/12/18

(4)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST250

AS 07/12/18

(X4)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

DO 07/12/19

Job Completion



U 07/12/19

W/O:		WORK ORDER CHANGES					
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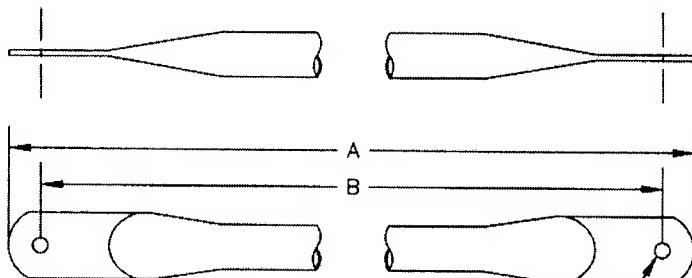
NOTE: Date & initial all entries



ACOPY
COP

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. E	SHEET 1 OF 1
		D2565		
DATE		TITLE	SCALE	
04.05.05		STRUT		1:3
A	96.05.03	NEW ISSUE		
B	97.03.15	CORRECT D2565-111 DIM. A		
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)		
D	02.06.05	ADD -3XX PARTS; ADD FINISH		
E	04.05.05	ADD D2565-401-411; RMV ANGLE D		

RELEASED
04.05.05



DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	—
D2565-109	12.31	11.51	—
D2565-111	13.65	12.85	—
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	—
D2565-209	15.16	14.36	—
D2565-211	14.14	13.34	—
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	—
D2565-309	20.17	19.37	—
D2565-311	16.30	15.50	—
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	—
D2565-409	9.34	8.54	—
D2565-411	13.81	13.01	—

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF. DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

W036360

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